

Date: Monday, 4/23/2007 1:52:37 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE	
Job Number	: 31993				
Estimate Number	: 12728				
P.O. Number	: N/A		Part Number	: D353541	
This Issue	: 4/23/2007	S.O. No. : N/A	Drawing Number	: D3535 UNDER REVIEW	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: MA		Drawing Revision	: A B PH 07-04-36	
Previous Run	: N/A		Material	: N/A	
Written By			Due Date	: 4/30/2007 Qty: 20 Um: Each	
Checked & Approved By					
Comment	: Est Rev A New Issue 07-02-15 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S20GA	304/316 .040 Sheet	
		Comment: Qty.: 0.5355 sf(s)/Unit Total : 10.7100 sf(s) 304/316 .040 Sheet (M304S20GA)	
		Batch: M101873 SAN 07/04/20	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Deburr if necessary → SAN 07/05/01 26 Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. Identify as D3535-41 Form Joggle on brake using Jig DT8158 as per Dwg D3535	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31993

Part Number: D353541

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1107/05/02 26

7.0 POWDER COATING

POWDER COATING



M161601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

11

07.05.03

26

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-f 07/05/04

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP 15

m-f 07/05/04

26

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1107/05/04

26

Job Completion



U 07/05/04

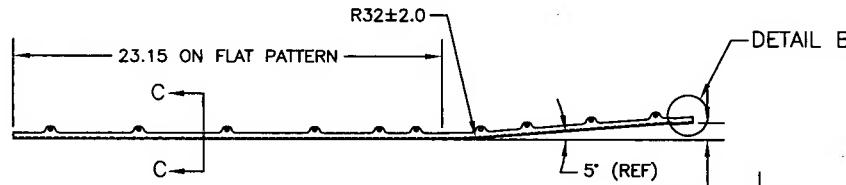
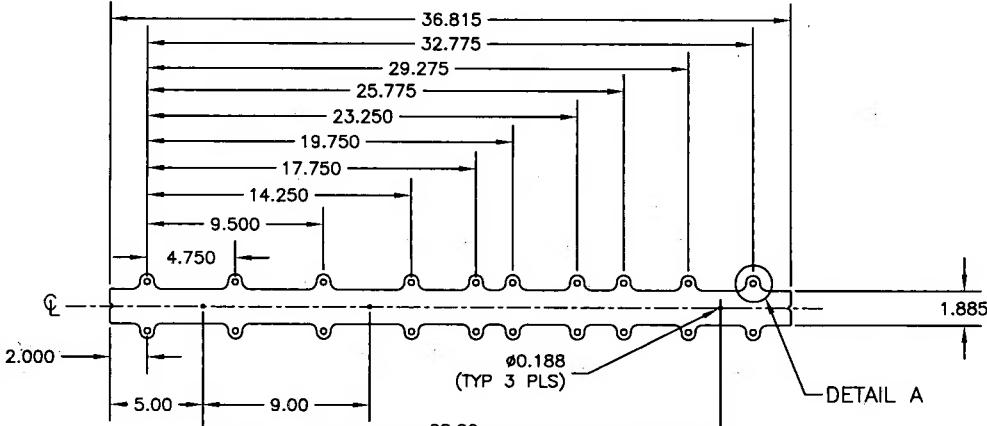
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

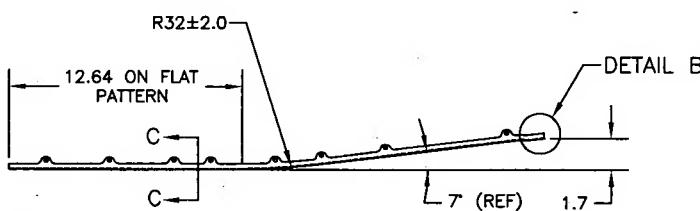
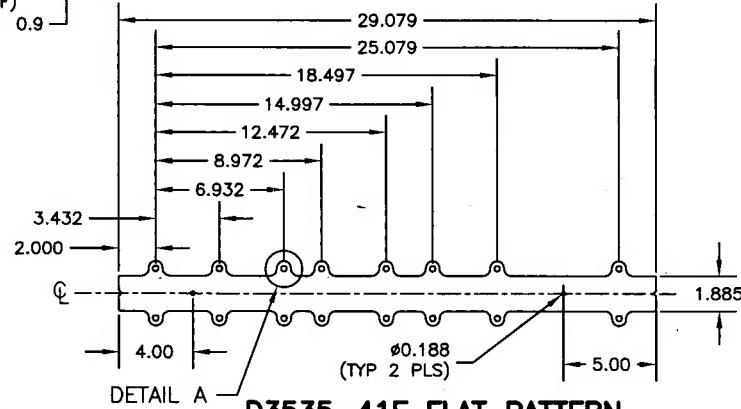
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE



D3535-39 BEND DETAIL



D3535-41 BEND DETAIL

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	SHEET 6 OF 7
		SCALE 1:10

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NO. 31993

WORK ORDER

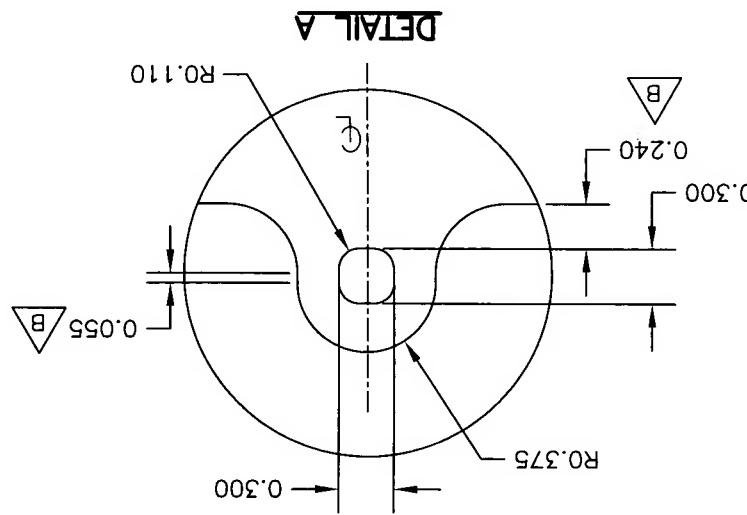
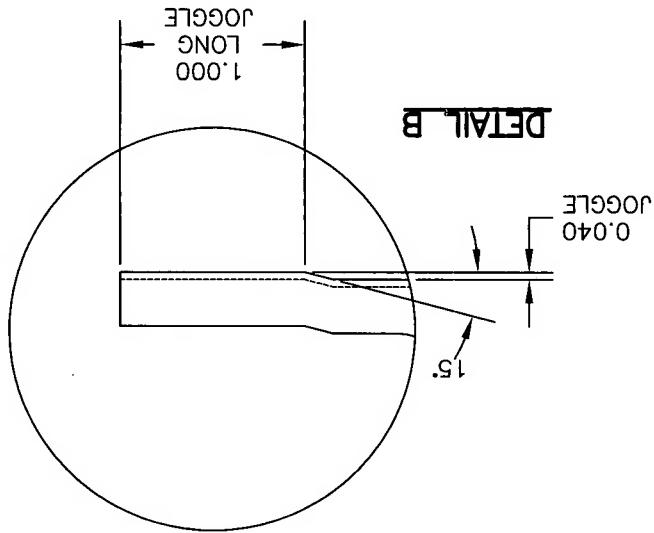
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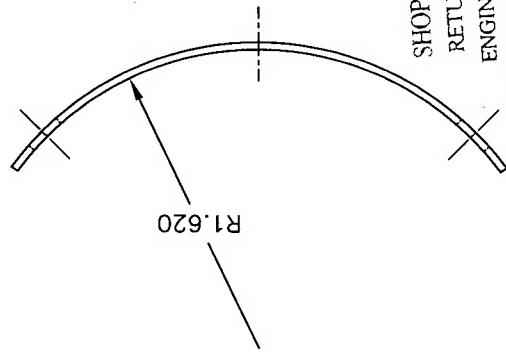
- NOTES**
- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
 - PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
 - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - ALL DIMENSIONS ARE IN INCHES
 - BREAK ALL SHARP EDGES TO 0.010 MAX
 - IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
 - SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY <i>Pf</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3535
DATE	07.04.17	TITLE WEARSHOE
REV. B SHEET 7 OF 7 SCALE 1:1		

PRELIMINARY ISSUE



SECTION C-C



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DART AEROSPACE LTD

Work Order: 31993

Description: Wear Plate

Part Number: D353541

Inspection Dwg: D3535 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 4.00	+/- 0.030	4.011	✓		Vern	
B Ø0.188	+ 0.005 - 0.001	0.190	—		Vern	Vertical
C 5.00	+/- 0.030	5.006	✓		Vern	
D 1.885	+/- 0.010	1.887	✓		Vern	
E 29.079	+/- 0.010	29.079	✓		M-T	
F 25.079	+/- 0.010	25.079	✓		Vern M-T	
G 18.497	+/- 0.010	18.500	✓		M-T	
H 14.997	+/- 0.010	15.000	✓		M-T	
I 12.472	+/- 0.010	12.475	✓		M-T / vern	
J 8.972	+/- 0.010	8.971	✓		Vern	
K 6.932	+/- 0.010	6.934	✓		Vern	
L 3.432	+/- 0.010	3.433	✓		Vern	
M 2.000	+/- 0.010	2.006	—		Vern	Vertical
N 0.300	+/- 0.010	0.299	✓		Vern	
O 0.300	+/- 0.010	0.300	✓		Vern	
P 0.038	+/- 0.010	0.038	✓		Vern	
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	SAD	Audited by:		Prototype Approval:	N/A
Date:	07/04/30	Date:	07/04/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	